

Work Order ID 89763

89763

Page 1

Wednesday, September 05, 2012 10:30:56 A

Item ID: 647.0111 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Panel
 Start Date: 9/5/2012 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 9/28/2012 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: Date: 12-09-15 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.0100	A								

110

0.00

110

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

20 0 Jm 12-9-16

20 0 Jm 13-9-16

Work Order ID 89763***89763***

Page 2

Wednesday, September 05, 2012 10:30:56 A

Item ID: 647.0111

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Panel

Start Date: 9/5/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 9/28/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC8- Inspect parts - second check

0.00

Smb

130

QC

Memo

0.00

12-9-17

20

Quality Control

140

Outsource process-Anodize per QSI017 4.1.10.1

0.00

D/O: 17998 A.T.G

140

Outsource4

Memo

0.00

CL 12/09/20 20

Outsource process - Anodize

HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)

150

Receive & Inspect for Damage & Mat'l Certs

0.00

150

Packaging

Memo

0.00

Puff 20 (20)

Packaging

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Wednesday, September 05, 2012 10:30:56 A

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 Smb 12/10/25				20			
170 *170* SprayPaint Spray Painting	Memo PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2) BATCH: 122543	0.00 0.00				20	Ø	Ø	AS 12-11-17
180 *180* QC Quality Control	QC14- Inspect Spray Paint Memo	0.00 0.00				comb 20			

Work Order ID 89763***89763***

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Wednesday, September 05, 2012 10:30:56 A

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Revision ID:

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Item Name: Panel

Start Date: 9/5/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 9/28/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <i>ST</i>	0.00							
190									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

*Reship 20**12/11/22**MF*
12-11-21

Picklist Print

Page 1

Wednesday, September 05, 2012 10:31:00 AM

Work Order ID: 89763

89763

Parent Item: 647.0111

647 0111

Parent Item Name: Panel

Start Date: 9/5/2012

Required Date: 9/28/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 12.08.14 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.063

Purchased

No

110

sf

136.5200

1.0988

~~23.13265~~

M2024T3S 063

**

23.5

JM12-9-16

2024-T3 .063 sheet

Location

Loc Qty

Loc Code

MAT022

136.52

119916

67.1

121197

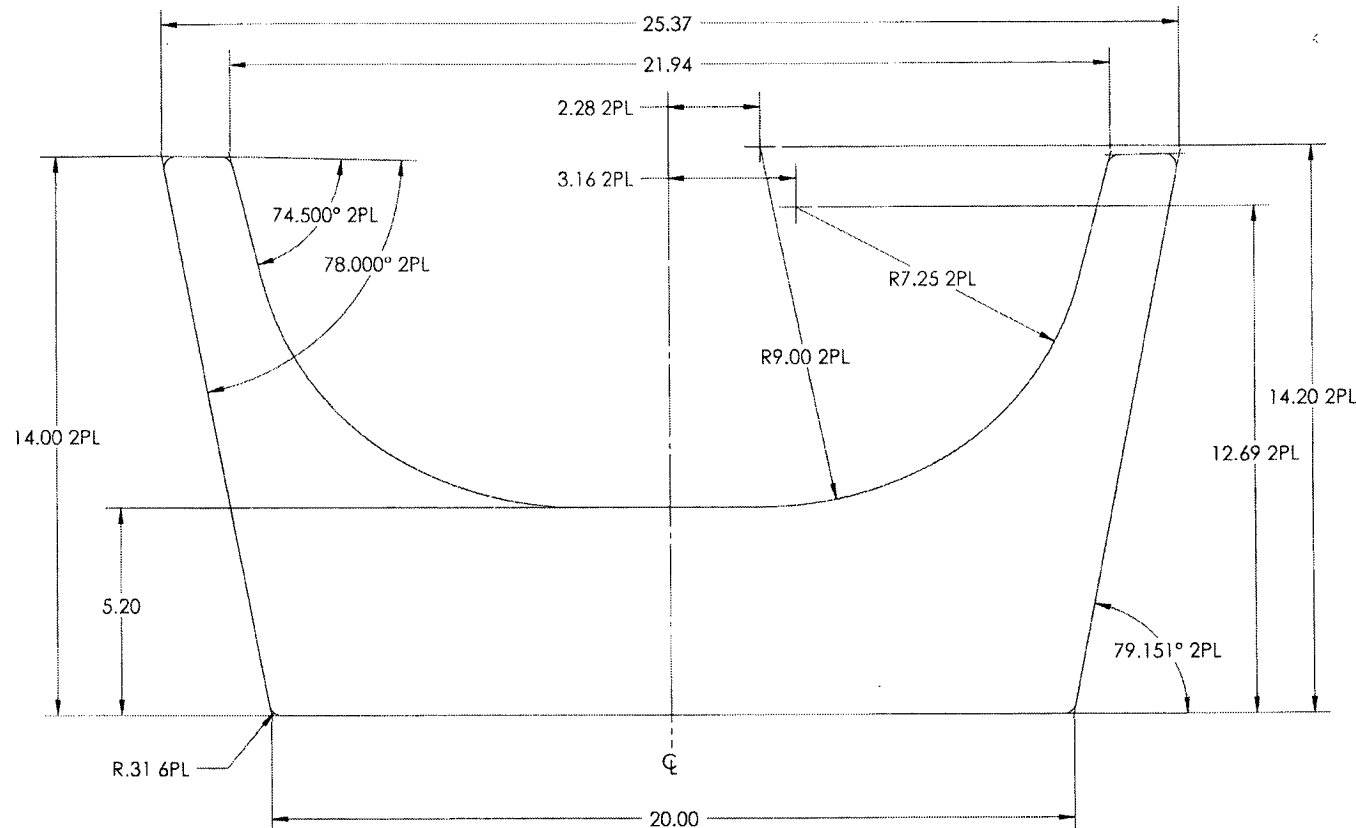
69.42

119916

~~121197~~

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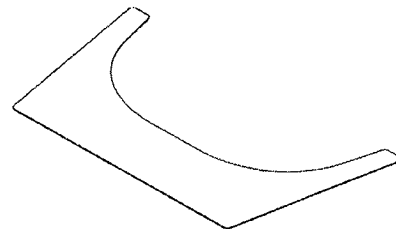
REV	DESCRIPTION	DATE	APPROVED
REV	LAST PRODUCTION REVISION: P22		N/C
N/C	INITIAL RELEASE	06/28/09	P. BRAVO
A	INCORPORATED ECH 02702, 02804, 03009	04/26/11	P. BRAVO



89763
PL12-09-5

NOTES:

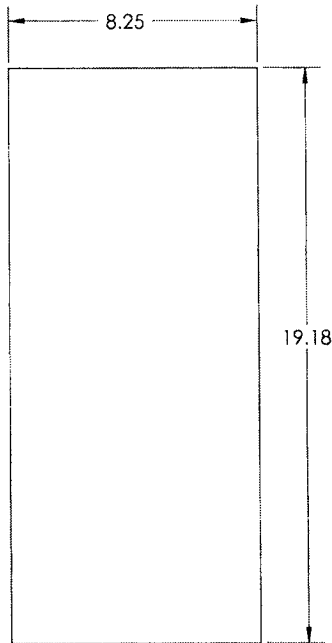
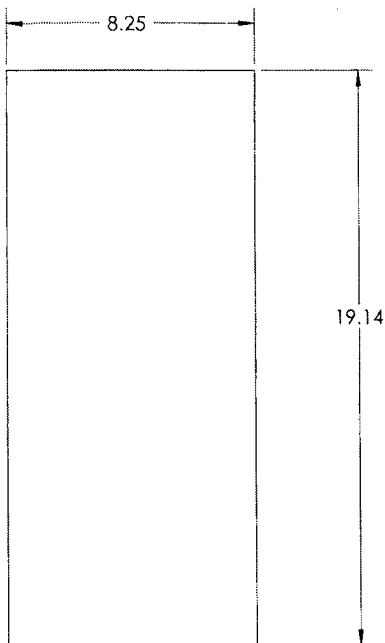
1. MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4.
2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; PRETREAT PR-148 ADHESION PROMOTER; PRIME IAW MIL-P-23377 J TYPE I CLASS N.
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120.
5. MATERIAL: 304 SS IAW AMS 5643.
6. FINISH: PRIME IAW MIL-P-23377 J TYPE I CLASS N.



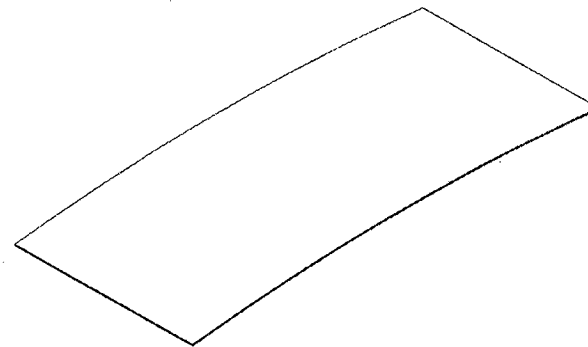
647.0110

		647.0116	DOUBLER	△	△
		647.0115	CLIP	△	△
		647.0114	CLIP	△	△
		647.0113	STRUT DOUBLER	△	△
		647.0112	STRUT BRACKET	△	△
		647.0111	PANEL	△	△
		647.0110	ROOF DOUBLER	△	△
	FIND #	PART #	DESCRIPTION	MATL	SPEC.
QTY			PARTS LIST		
NEXT ASSY (S)			APICAL INDUSTRIES		
646.9500			2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300		
DRAWING APPROVAL BY DATE CONSTRUCTION			SHEETMETAL		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°			REV A		
			SIZE	CAGE CODE	DWG. #
			B	07M26	647.0100
			SCALE NONE		SHEET 1 OF 6

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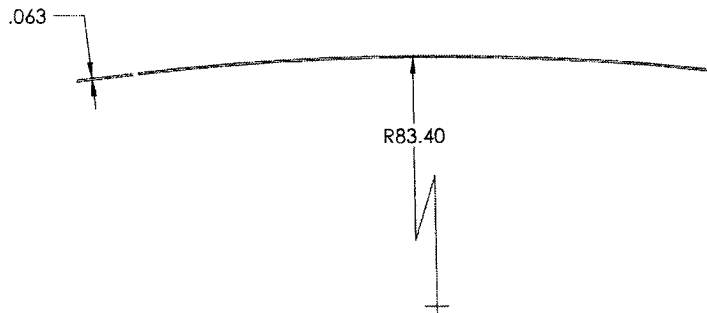


FLAT PATTERN



647.0111

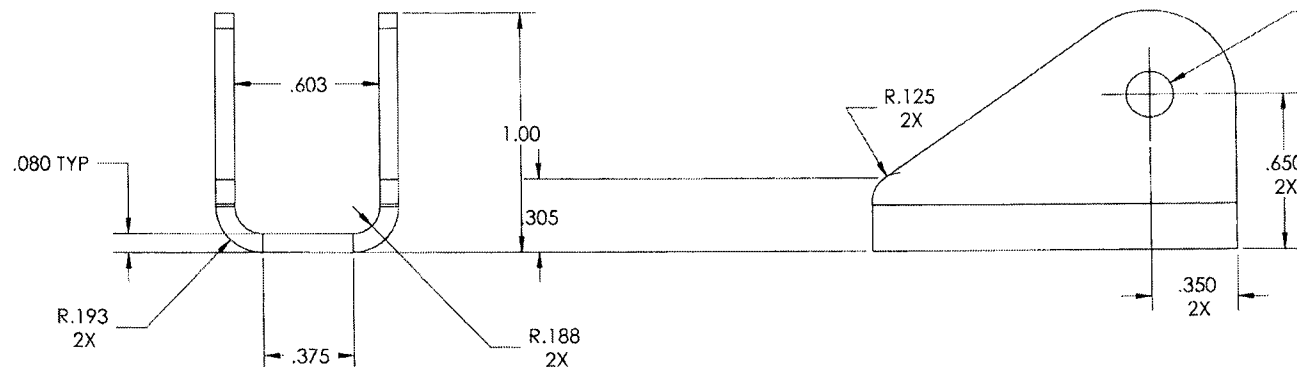
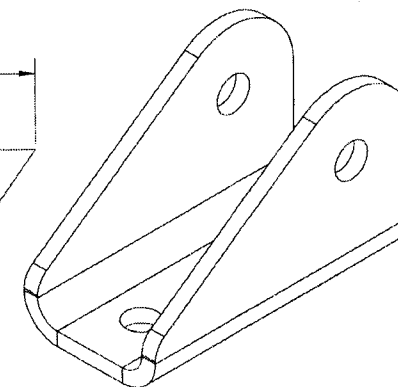
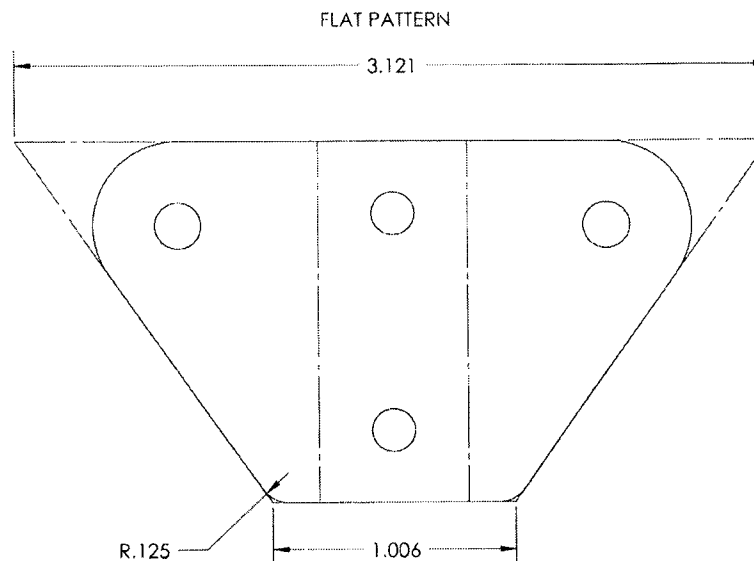
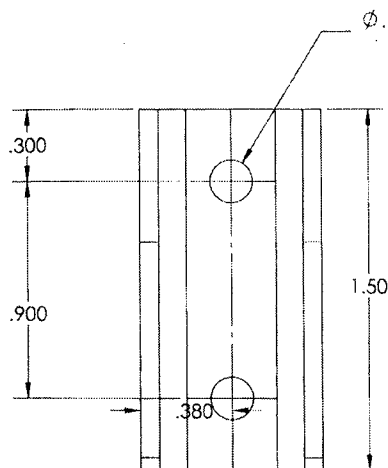
89743



ORIGINAL DATE DUCED: 10-05-09		APICAL INDUSTRIES	
DRAWN BY: P. BRUNO		2608 TEMPLE HEIGHTS DR.	
CHECKED BY: P. BRUNO		OCEANSIDE, CA 92056-3512 (760) 724-5300	
DRAWING APPROVAL P. BRUNO		SHEETMETAL	
CONTRACT NO.		SHEET 2 OF 6	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 ANGLES ±.5°		SIZE: CAGE CODE: B 07M26 DWG. NO: 647.0100 SCALE: NONE	REV: A SHEET 2 OF 6

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REV.	DESCRIPTION	DATE	APPROVED

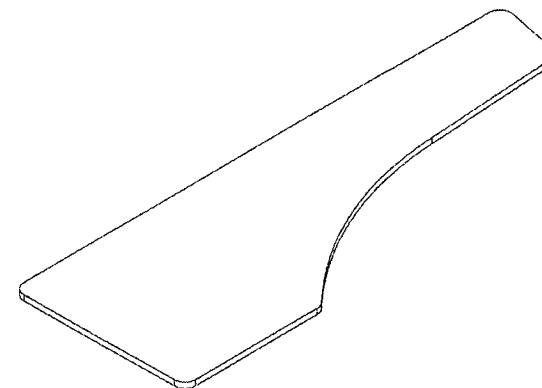
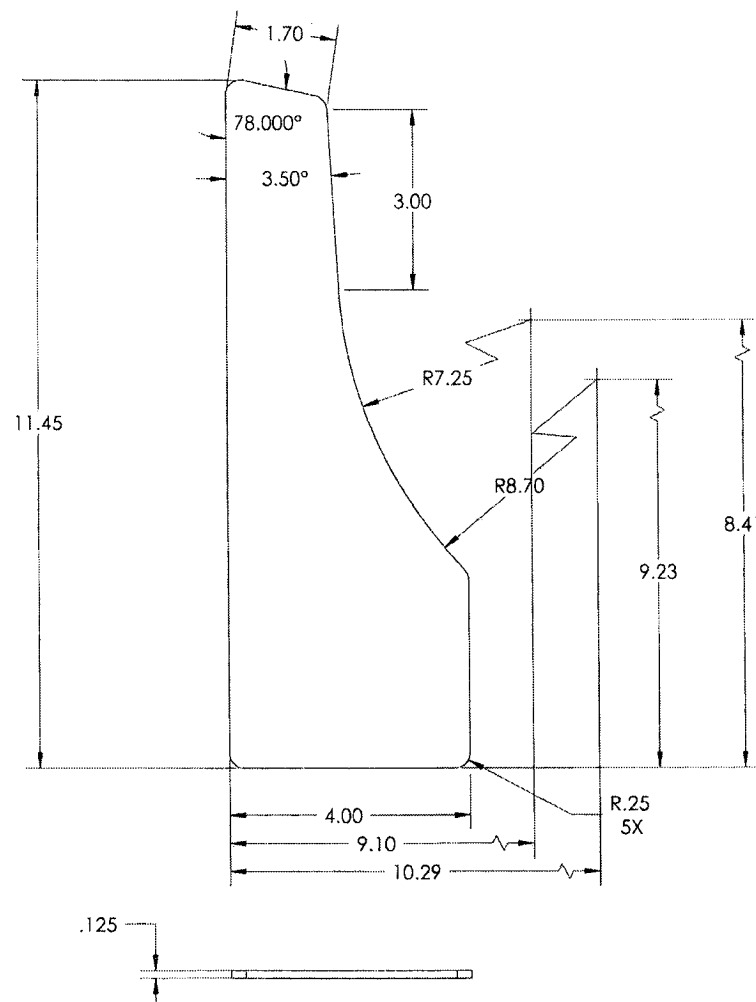


89763

ORIGINAL DATE (DD-MY-YY) 09-28-07 DRAWN BY P. BOHANNON CHECKED BY P. BOHANNON APPROVED BY H. BRADY CONTRACT NO.	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300 SHEETMETAL
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.01°	SIZE / LARG CODE B / 07M26 DWG. NO. 647.0100 SCALE NONE
REV. A	SHEET 3 OF 6

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



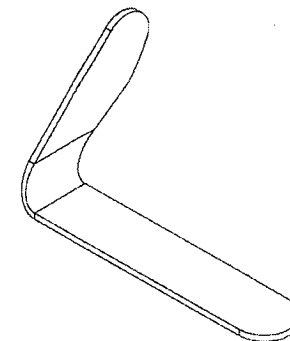
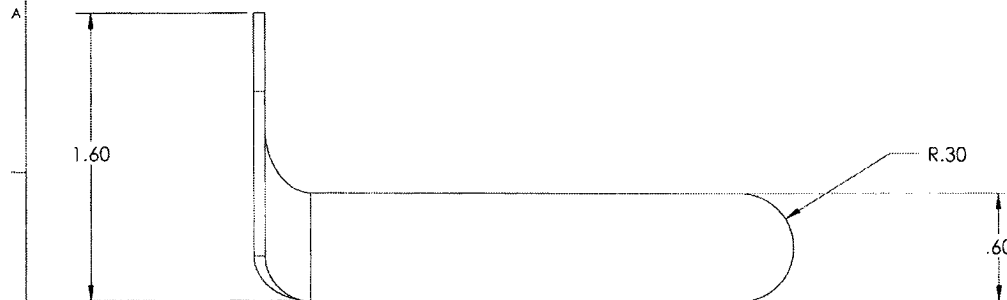
647.0113

897163

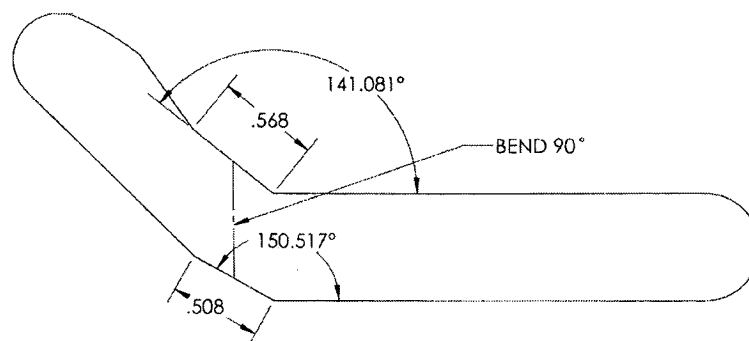
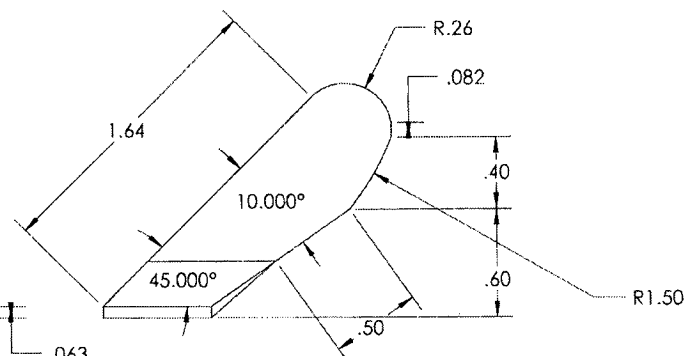
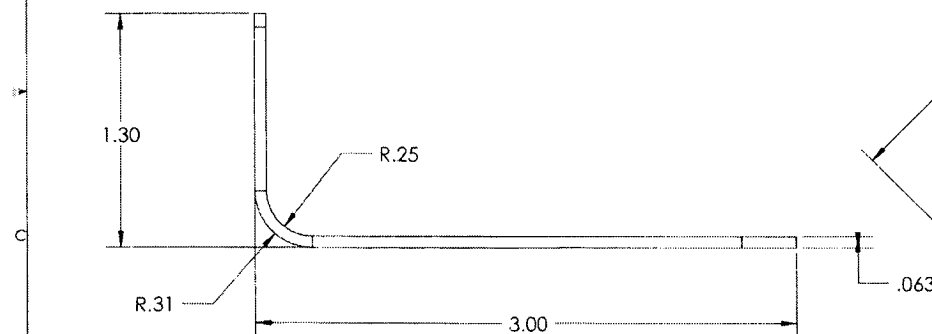
ORIGINAL DATE (MM-DD-YY) 05-26-07		APICAL INDUSTRIES	
DRAWN BY P. ROSANO	CHECKED P. ROSANO	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL P. ROSANO		SHEETMETAL	
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE FRACTIONS DECIMALS ±.01 2 PLACE DECIMALS ±.005 ANGLES ±.5°		SHEET B	REV. A
CAGE CODE 07M26		DWG. NO. 647.010J	
SCALE NONE		SHEET 4 OF 6	

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



647.0114 SHOWN
647.0115 OPPOSITE



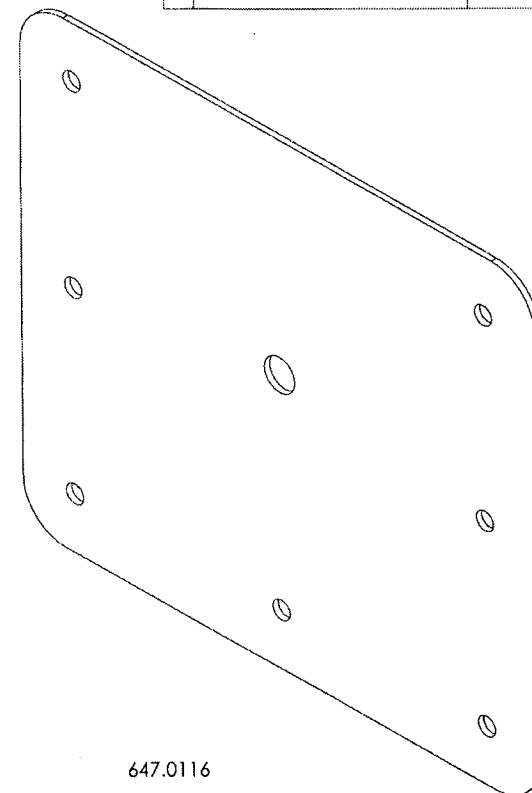
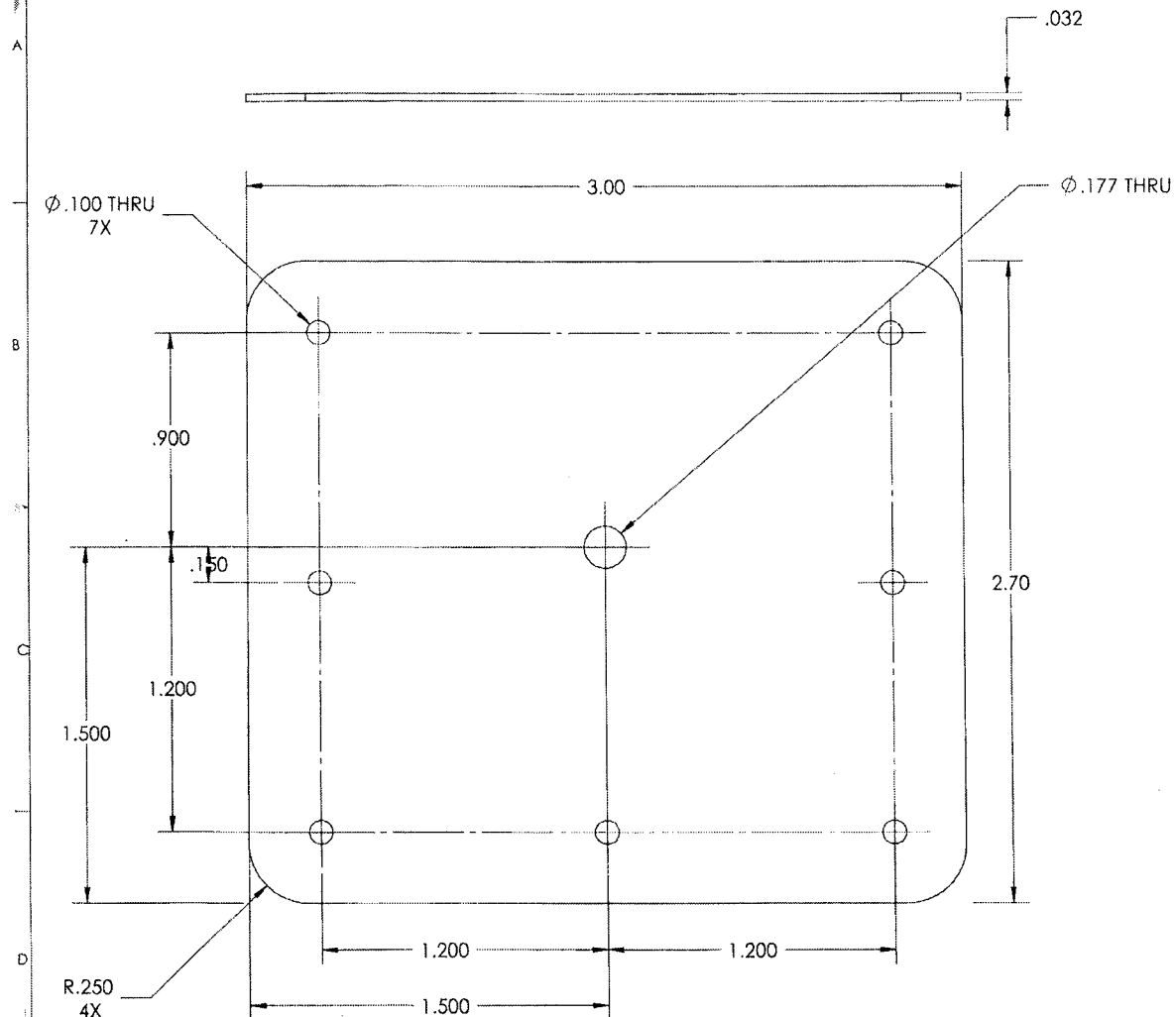
FLAT PATTERN

89143

ORIGINAL DATE APICAL INDUSTRIES		APICAL INDUSTRIES	
DRAWN BY: C. BEAVER		2608 TEMPLE HEIGHTS DR.	
P. ROSSANO		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL		SHEETMETAL	
P. BEAVER		SEE CASH CODE	
P. ROSSANO		DWG. NO. 647.0100	
C. CONTRACT NO.		REV. A	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°		SCALE NONE	
		SHEET 5 OF 6	

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



647.0116

89243

EXPIRATION DATE 12/31/04 1P 05:28:09		APICAL INDUSTRIES	
DRAWN BY R. ROSANO	CHECKED P. BRAYO	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAYO	CONTRACT NO.	SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$		SIZE B	CODE C026
		DWG. NO. 647.0100	REV. A
		SCALE NONE	SHEET 6 OF 6



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO17998

Purchase Order Date 9/26/12

PO Print Date 9/26/12

Page Number 2 of 3

Order From :

VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Contact Name

Vendor Phone

Vendor Fax

Vendor Account Nbr

613-446-4544

613-446-4556

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

Destination-Collect

3

90608

D4410-041 CO-PILOT
COLLECTIVE HEAD

9/28/12

1.00 Dart Truck

\$27.5000

\$27.50

Yes

Special Inst:

BLACK ANODIZE AS PER DWG D4410
REV. PB10
B90608

ANODIZE PER MIL-A-8625F TYPE I OR
IB OR IC
OR II OR IIB CLASS 2

4

89703

647.0110 ROOF
DOUBLER

9/28/12

20.00 Dart Truck

\$5.5000

\$110.00

Yes

Special Inst:

BLACK ANODIZE AS PER DWG 647.0110
REV.A
B89703

FINISH; HARD ANODIZE IAW MIL-A-
8625 TYPE III, CLASS 2,
COLOR BLACK

89763

647.0111 PANEL

9/28/12

20.00 Dart Truck

\$5.5000

\$110.00

Yes

Special Inst:

BLACK ANODIZE AS PER DWG 647.0111
REV.A
B89763

FINISH; HARD ANODIZE IAW MIL-A-
8625 TYPE III, CLASS 2,
COLOR BLACK

No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required **YES** NO

Change Nbr:

1

Change Date: 9/26/12



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 62000

Date: 24-Oct-12

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To


DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
1 lot	Part: ASST 20 PCS 647.0110 20 PCS 647.0111 40 PCS 647.0116 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20120646	Rev:	Line:
PO: PO17998			
Certificate of Conformance A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order. ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY DATE : <u>24/10/12</u> CERTIFIED SIGNATURE : <u></u> RECEIVER SIGNATURE : _____			